

Blue

Dart Aerospace Ltd.

Date: Wednesday, 12/11/2008 1:41:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 43389
 Estimate Number : 10326
 P.O. Number :
 This Issue : 12/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 42568

Drawing Name : BLUE - LUG EXTRUSION

Part Number : D27317
 Drawing Number : D2731 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 10/12/2008

Qty: 100 Um: Each

Written By :
 Checked & Approved By : JUD 08.11.12
 Comment : Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 7.1715 f(s)
 Lug Extrusion D2423
 Batch: B43722

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 extrusion to .82"

Batch:

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2731-7.

2-Check for crack while loading into the machine.

3-Tumble

4-Deburr any rough edges after tumbling

4.0 Q82 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 Q88 SECOND CHECK



Comment: SECOND CHECK



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Seq. #: Machine Or Operation: Description:

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(100)

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

FL 09/01/12

7.0 SPRAY PAINTING SPRAY PAINTING



Comment: -PRIME B 110199

-PAINT DELFLEET BLUE B 110077

-CLEAR DELFLEET B 110161

ml 09 02 13 22

8.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT POWDER COAT

IT 09-02-17 (22)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



(22)

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 420

9/2/18

sq

10.0 QC21 FINAL INSPECTION/W/O RELEASE



09/02/26

Comment: FINAL INSPECTION/W/O RELEASE

78

Job Completion



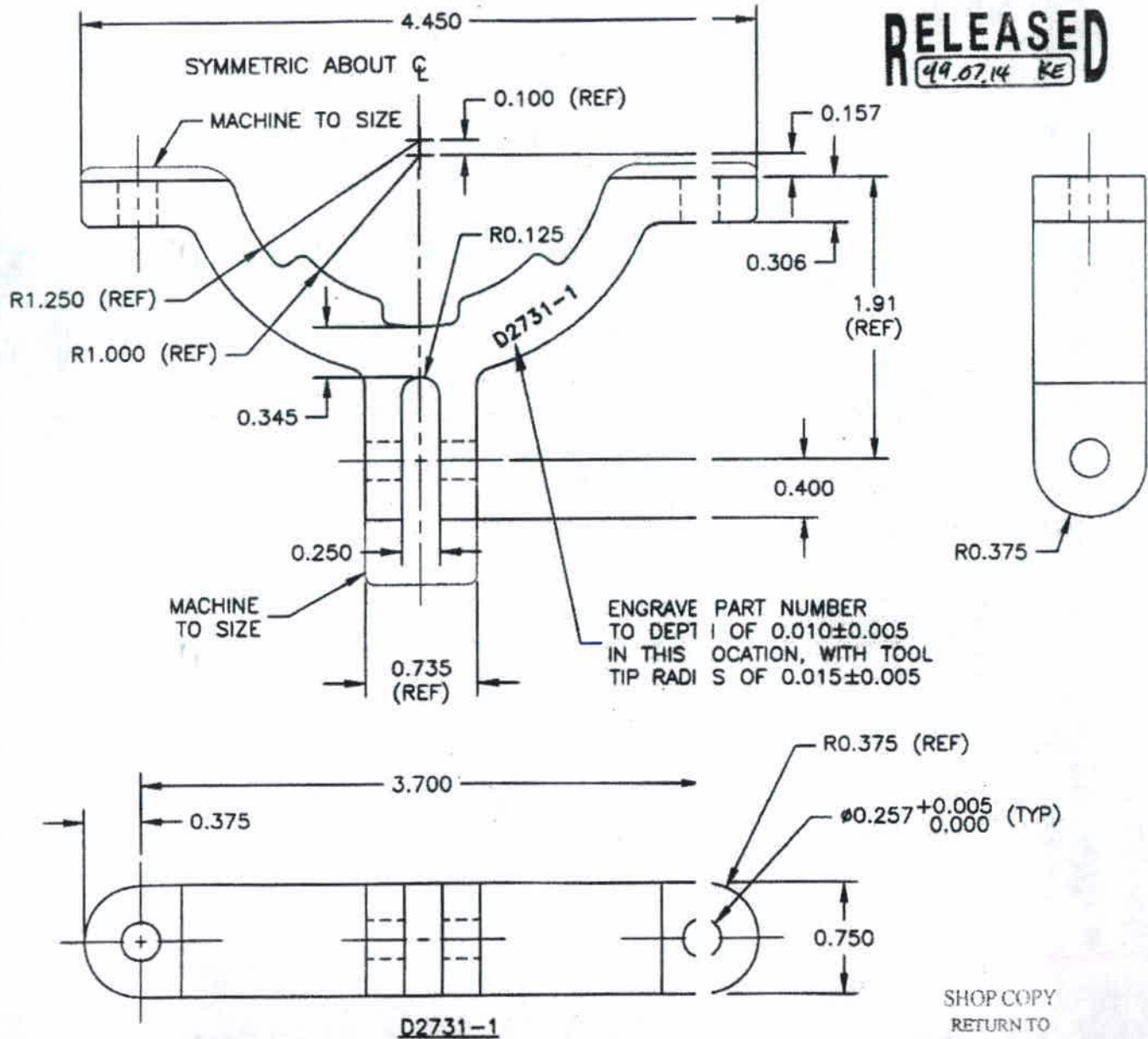
MF 09-02-18



DESIGN	LE	DRAWN BY	RF
CHECKED	LE	APPROVED	[Signature]
DATE	99.07.06		
A	98.05.13		
B	99.07.06		

DART AEROSPACE USA, INC.
FAIRCHILD INTERNATIONAL AIRPORT, WA

DRAWING NO.	REV. B
D2731	SHEET 1 OF 4
TITLE	SCALE
MOUNTING LUG	1:1
NEW ISSUE	
REVISED DIMENSIONS	



RELEASED
49.07.14 KE

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 42389